	er ID 62762 er 07, 2010 3:12:24	PM									Page 1
	D206-642-541	!		Accept				Setup	Start		
Revision ID: Item Name:	Replacement Skidtube	(2				Stop		
Start Date: Required Date:		Qty: 1.00 Qty: 1.00	183141 1841 1841 184141 1841 1841		Cust Item I Customer:	D:					
Reference:											
Approvals:	Process Plan:		Date://0/5/	7 Tooling:	Da	ate:		Run	Start		
	QC:	, / (Date:	SPC (Y/N):	Da	ate:			Stop		
Sequence ID/ Work Center ID	Operat Descrip	1		Set Up/ Run Hours	Tool ID		lan Acce ode Qty	pt Rej Qty		Reject Number	Insp. Stamp
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W/O:			W	ORK ORDER	CHANGES					
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Part No.	:	PAR #:			` *					
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NCR:		V	VORK OR	DER NON-CON	IFORMANC	E (NCR)			£
DATE	STEP	Description of NC	Initial	Corrective Action		Sign &	Verific			Approval
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Work Order ID 62762

Thursday, Ożtober 07, 2010 3:12:24 PM



Page 2

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name: Replacement Skidtube

Start Date:

10/7/2010

Start Oty: 1.00

Required Date: 10/15/2010 Req'd Qty: 1.00

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop



Sequence ID/

Operation Description Set Up/ **Run Hours** **Tool ID**

Tool # Plan

Code

Accept **Qty**

Reject Otv

Reject Number

Insp. Stamp

Work Center ID 110

Skidtubes

Skidtubes

Skidtubes

0.00

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004. AR Aluminum Rod Batch: 1113 65

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

10-10-13

Dart Aerospace	Ltd	
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W/O:			V	VORK ORDER CHANGES			<u> </u>	
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Part No	.D201	0-642-541 PAR#:	Fault Ca	tegory: Slightly N	CR: (Yes)	No DQA;	Date:	10.11.08
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NCR:	2762	Wo	ORK OR	DER NON-CONFORMANC	E (NCR)		
DATE	STEP	Description of NC Corrective Action Section B Verifi				Verification	Approval	Approval
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Work Order ID 62762

Required Date: 10/15/2010

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Page 3

Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Oty: 1.00 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/ Work Center ID

120

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

130

QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / 4 Prod Mgr	Approval QC Inspector
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Part No):	PAR #: Fault Category: NCF	2. Vec	No DQ	\• ,	Date:	

Disposition: _

QA: N/C Closed: _____

Date: __

NCR:			WORK ORD	ER NON-CONFORMANC	E (NCR)			
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NOTE: Date & initial all entries

Resolution:

Thursday, October 07, 2010 3:12:24 PM

Item	ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 10/15/2010

10/7/2010

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

Approvals:	
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Process Plan:

Date:

Tooling: Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID**

150

Skidtubes Skidtubes

Operation Description

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Skidtubes

0.00

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015. A/RDDSikaflex-2910/////

Sikaflex expire date: O/20/ Start: O/26 Time: Since O/20 Consists of Consists

8610/10/28

QC5- Inspect part completeness to step on W/O

0.00

OC

Memo

0.00

D 10110/29

160

Quality Control

Dart Aerospace

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W/O:	T		W	ORK ORDER CHAN	IGES	1	· · · · · · · · · · · · · · · · · · ·			
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Part No	:	PAR #:	_ Fault Cat	tegory:	NCF	R: Yes I	No DQA	\ :	_ Date: _	
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Item	ID.
Item	117:

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

Replacement Skidtube

D206-642-541

10/7/2010 Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Reference:

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Process Plan:

Date:

Tooling:

0.00

Date:

Start Run

Qty



Required Date: 10/15/2010

QC: ____

Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ **Work Center ID**

170



Skidtubes

Operation Description

Skidtubes

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code Accept **Qty**

Reject Reject Number

Insp. Stamp

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

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W/O:		***	WORK ORDER	CHANGES	····			
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Work Order ID 62762

Thursday, October 07, 2010 3:12:24 PM



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Item ID: **Revision ID:** D206-642-541

Accept



Setup Start



Item Name:

Replacement Skidtube

Start Date:

Start Qty: 1.00 10/7/2010

Req'd Qty: 1.00 **Required Date:** 10/15/2010

Operation

Description

Skidtubes

Cust Item ID: Customer:

Reference:

Ap	provals:	
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Process Plan: _____ Date: ____ Tooling:

Date:

Tool ID

Start Run



Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Reject Reject Insp.

Number

Stop

Stamp

Sequence ID/ Work Center ID

190

Skidtubes

Skidtubes

0.00

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. User aluminum rod

A/R 🗆 Aluminum Rod 🗆 M/11385

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200

QC

Memo

QC5- Inspect part completeness to step on W/O

0.00

Accept

Qty

Quality Control

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng'/ Prod Mgr	Approval QC Inspector			
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Work Order ID 62762

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Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

Req'd Oty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Date:

Run

Start Stop



Date:_____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Accept

Reject

Reject Insp.

Work Center ID

210

Sequence ID/

OC

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Code

Qty

Qty

Number Stamp

220



Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

230



Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

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W/O:			WC	RK ORDER CHANGES	:				
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Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R \square N/A \square LPS-3 \square _ $\lambda\lambda$ _1 0 9 9 5

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R □ Sikaflex-291 □ ///// 51dg Sikaflex expire date: □ ((\c(

260

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

Page 8

Insp.

Stamp

W/O:			WO	RK ORDER CHANGES		i		
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Resolution:			Disposition	:0	A: N/C C	losed:	Date: _	
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Work Order ID 62762

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Item ID:

D206-642-541

Accept



Setup Start

Stop

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description



Cust Item ID:

Customer:

Reference:

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Process Plan: ____ Date:

Tooling:

Date:

Date:

Run Start

Required Date: 10/15/2010

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

10(11/04)

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID 270

Sequence ID/

HandFinish Hand Finishing HAND FINISHING RESOURCE #1

Memo

0.00

0.00

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274 A/R \square Sikaflex-291 \square $M(115114<math>\square$

Sikaflex expire date:

1110-

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 LPS-3

Batch: W/A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R \square Sikaflex-291 \square \triangle \triangle \triangle \triangle \triangle \triangle \triangle

Sikaflex expire date:

280

QC5- Inspect part completeness to step on W/O

0.00

0.00

M 10 11 04 (1

Quality Control

Memo

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W/O:]			WORK ORDE	R CHANGES	1			
DATE	STEP		PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector			
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Work Order ID 62762

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Item ID:

D206-642-541

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/7/2010

Start Qty: 1.00

Required Date: 10/15/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

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Process Plan:

Date: _____

Tooling:

Date:

Start Run

QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

290

Packaging

Operation **Description**

Identify as per dwg & Stock Location:_

Run Hours

0.00

Tool # Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

300

QC Quality Control QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

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W/O:			W	ORK ORDER CHANG	ES	i				
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Picklist Print

Thursday, October 07, 2010 3:12:28 PM

Work Order ID: 62762

Parent Item:

D206-642-541

Parent Item Name:

Replacement Skidtube



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Page 1

Comments:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23

Added SS Wearplates & Gaskets JLM

IPP Rev:D 07-12-06 08-04-17

replace NAS1515H3L to D3672-1 DD

IPP Rev:E

as per PAR 08-015 DD verified by:EC

IPP Rev:F

08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09

revise details DD verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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3				<u>Location</u> LG	47575	<u>Loc</u>	73 25	Loc Code	0-	D		0 -10	0-1-
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Parent Item:

Work Order ID: 62762

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured

Manufactured

190

Each

65.0000

12

Cross Bolt Spacer

Location	Lo	c Oty
LG		65
58545		2
60652		4
61496		59
	190	Each

216.0000

12

D3275-1

Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	216	
53453	8	
61646	102	
62399	106	

250

CR3212-4-03

Purchased No

1,888.000

Cherry Rivet

4 - 4.

Location .	Loc Qty	Loc Code
ST311	1888	
111359	5	
112314	2	
114436	448	
114450	71	
114859	1362	
	250 Each	52.0000

D3415-041

Manufactured No

Each

Nut Plate

Location	Loc Oty	Loc Code
ST056	52	
<u>33842</u>	52	

Dart Ae	rospace	e Ltd				' !				•
W/O:										
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:			_ Fault Cat	tegory:	NCR: Y	es N	o DQ	A:	Date:	
	R	esolution:	_ Disposit	ion:	QA: N/0					
NCR:		W	ORK ORI	DER NON-CONFORMA						
		Description of NC		n B	:	Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector
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· Thursday, October 07, 2010 3:12:28 PM

Work Order ID: 62762 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 CCR264SS3-3 Purchased No 250 446.0000 Each Cherry Rivet Location Loc Qty Loc Code ST311 446 112314 113539 44 113973 398 ALS4-1032-130 Purchased No 250 Each 1,147.000 78 10/11/61 Insert Location Loc Qty Loc Code PKG11 1098 114723 1098 M115911 ST282 10 110511 10 ST381 39 114654 39 D3536-15 Manufactured No 270 Each 21.0000 Gasket Location Loc Qty Loc Code FP 56055 60875 8 FP11 12 59238 1 62459 11

W/O:			ES	1								
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	:	PAR #:	_ Fault Cat	ult Category: NCR: Yes No DQA:						Date:		
	Resolution: Disposition:				QA: N/C Closed: Date:							
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Work Order ID: 62762 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 D3536-23 Manufactured No 270 8.0000 Each Location Loc Qty Loc Code B 63391 X FP011 8 61237 D3536-35 Manufactured No 270 Each 23.0000 Gasket Location Loc Qty Loc Code FP012 23 58683 1 61692 10 62462 12 D3536-39 Manufactured No 270 Each 12.0000 Gasket Location Loc Qty Loc Code FP12 12 58215 1 58571 11 D3535-15 Manufactured No 270 Each 12.0000 Wearshoe Location Loc Qty Loc Code FP18 12 61241 6 62241

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Part No	:	PAR #:	Fault Ca	NC	R: Yes	No DQ	A:	Date: _		
	Re	esolution:	ution: Disposition:			: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFO	RMANCE	E (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng			Sign 8	k Secti	cation on C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 62762 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 D3535-35 Manufactured 270 8.0000 Each Wearshoe Location Loc Oty Loc Code FP018 8 60865 8 D3535-39 Manufactured 270 No Each 17.0000 Wearshoe Location Loc Oty Loc Code FP18 17 58214 1 60233 16 D3535-23 Manufactured 270 No Each 19.0000 Wearshoe Location Loc Oty Loc Code FP 7 61830 7 FP021 20 60231 11 D3537-3 Manufactured No 270 Each 6.0000 Wearpad Location Loc Oty Loc Code FP17 1361674 60866

W/O:			WO	RK ORDER CHANG	ES							
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Part No	<u> </u>	PAR #:	Fault Cated	jory:	NCR: `	res N	lo DQ /	\ :	Date:			
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Work Order ID: 62762

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Wearpad

Manufactured No 270

Each

14.0000

Locatio	<u>on</u>	Loc	e Oty	Loc Code				
FP			1					
	55465		1					
FP017			6	0101	/ / .			
	61986		6	B621 B622	م (و (X 4		
FP17			7	13622	.09	x 5_		
	57713		3					
	60491		3					
	61640		1				4.	
		270	Each	29.0000	80	80		

AN960C10L

NAS1149C0332

Purchased

No

Il Million

M 10/11/04

washer

ST245 107534

100993

Loc Oty Loc Code 29

M 115832 29

AN960C416

NAS1149C0463

Purchased

No

Location

270

Each

100.0000



Location Loc Qty ST346

100 100 Loc Code

M115358 -XI

washer

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Work Order ID: 62762 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube **Start Date:** 10/7/2010 **Required Date: 10/15/2010** Start Qty: 1.00 Required Qty: 1.00 D3672-1 Manufactured No 270 Each 855.0000 10/11/01 Phenolic Washer Location Loc Qty Loc Code ST077 855 42329 150 52505 705 AN3C4A Purchased No 270 Each 1,650.000 **BOLT** Location Loc Qty Loc Code ST245 20 110139 20 ST303 42 115438 42 ST350 1588 114108 14 114416 12 114523 2 115300 560 1000 115589 AN4C5A Purchased No 270 Each 489.0000 10/11/01 **BOLT** Location Loc Qty Loc Code ST346 489 110552

485

112243

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W/O:			WO	RK ORDER CHANG	ES								
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Work Order ID: 62762

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2646

Aft Cap

Manufactured

Manufactured

53446

61322

270

Each

44.0000

10/11/01

Location		Loc Q	<u>ety</u>	Loc Code			
FP-4			39		_		_
	57332		39			χι	=
fp5			1				_
	61752	•	1				_
FP6			4		_		_
	52663		4			<u> </u>	_
	:	270	Each	31.0000	1	1	
						M	10/4/01/

15

15

D3413-1

Ring

Location	Loc Qty	Loc Code
ST473	31	
51586	1	

W/O:	-		W	ORK ORDER CHAN	GES		i			. *
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	DESIG	CP	DRAWN BY	DART AEROSPACE USA, INC.
ı	CHECK	(ED 1	APPROVED 🚜	DRAWING NO. REV. D
		#	-#	D3274 SHEET 1 OF 4
I	DATE			TITLE SCALE
	06.1	12.19		SKIDTUBE ASSEMBLY NTS
	Α		04.03.15	NEW ISSUE
Į	В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
	С		05.03.16	ADD -043; NEW INSERTS
	D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

Qty	Qty	1		1
-041	-043	Part Number	Description	
X		D3274-041	SKIDTUBE ASSEMBLY	1
	X	D3274-043	SKIDTUBE ASSEMBLY	1
1	1	D2600-1-240	EXTRUSION	
1	1	D2646	AFT CAP	
12	12	D2649	CROSS BOLT SPACER	. .
12	37	D3275-1	CROSS BOLT SPACER	P COPY
1	1	D3282-041	FLOAT WEB	JRN TO
1	1	D3285-1	CAF	1
1	1	D3413-1	11117	VEERING
1	1	D3415-041		OLLED COPY
1	1	D3535-15	WEARSHOE	DAMENDMENT
1	1	D3535-23	I WEAKSHUE	
1	1	D3535-35	I WEARSHOE	AT STATICE
1	1	D3535-39		LUKLIER
1	1	D3536-15	GASKET NO //	2762
1	1	D3536-23	GASKET	0/10/10
1	1	D3536-35	GASKET	BH010-1
1	1	D3536-39	GASKET	
9	9	D3537-1	WEARPAD	
1	1	D3537-3	WEARPAD	
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)	
80	80	AN3C4A	BOLT	İ
1	1	AN4C5A	BOLT	1
1	1	AN960C416	WASHER	1
80	80	AN960C10L	WASHER	1
2	2	CCR264SS3-3	RIVET	1
2	2	CR3212-4-03	RIVET	1
2	2	NAS1515H3L	WASHER	1

GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE

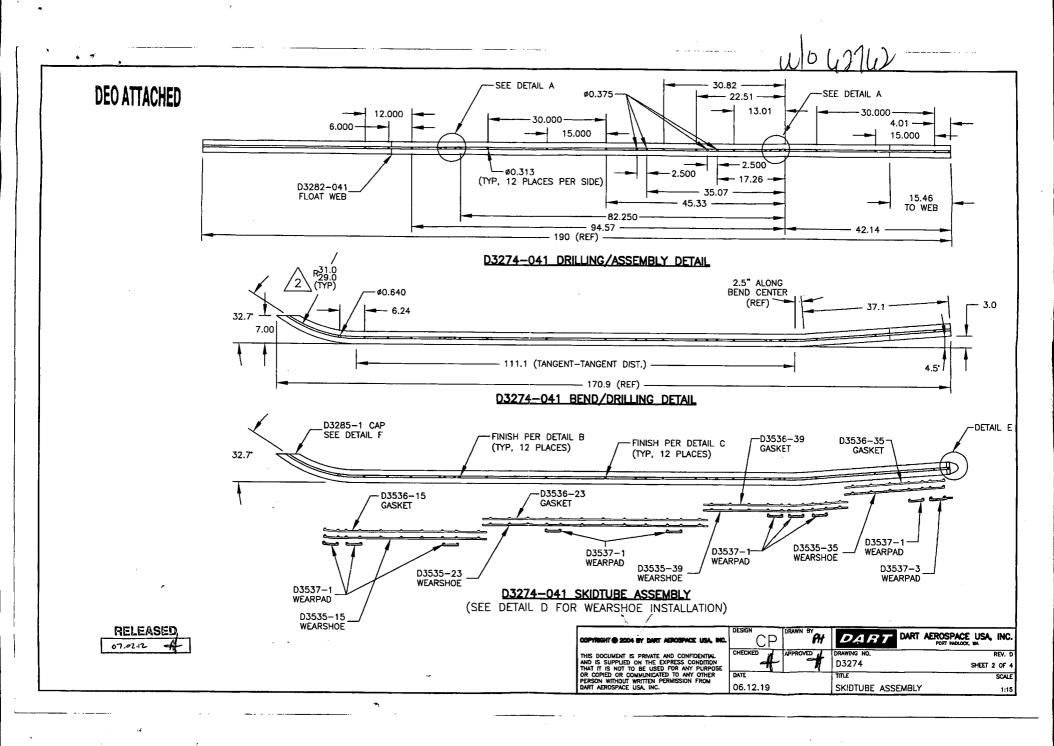
- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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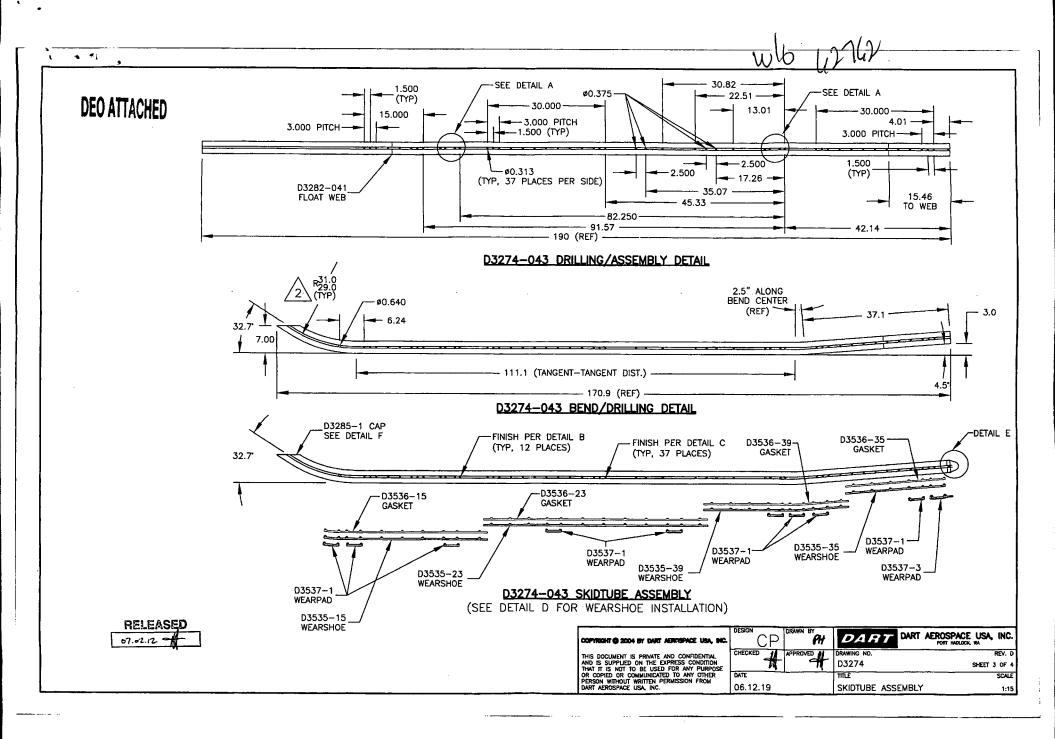
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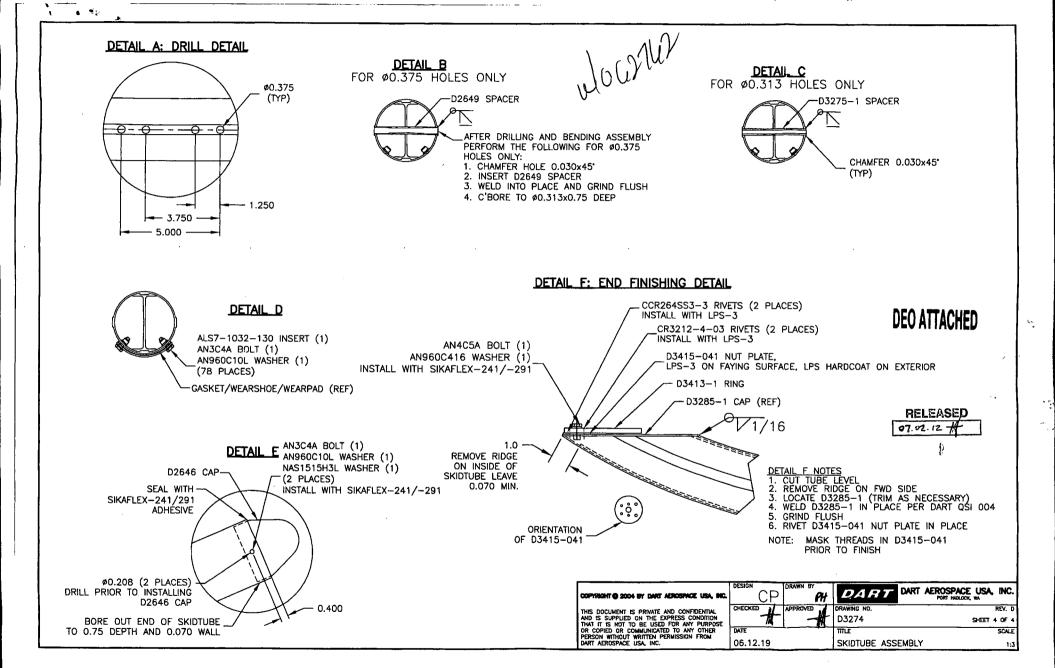


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DRAWING NO.	TITLE	1	REV. D	DART AEROSPACE USA, II	NC D.E.O. NO.		SHEET NO.	SCALE
D3274	SKIDTUBE	ASSEMBLY		ENGINEERING ORDER	D3274-D-1	Ω	SHEET 1 OF 1	NTS
DRAWN ** (P	CHECKED		MFG. APPR.	APPROVED ,	M.	DE APPR.	
DATE 09.	06.17	DATE 09.06.2	23	DATE 59/06/23	DATE	9/06/23	DATE 09.06.23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

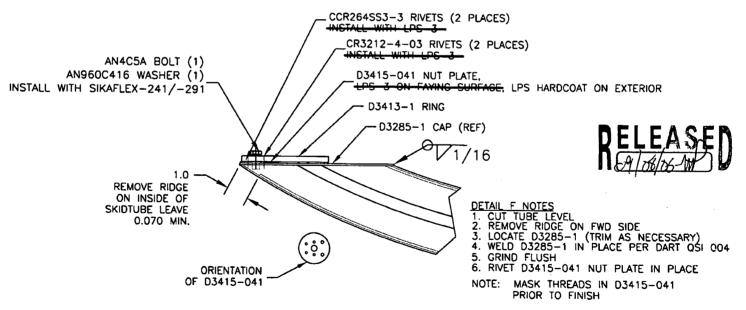
AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

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DETAIL F: END FINISHING DETAIL



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4		Description of NC		Corrective Action Section B		Verification	Approval	Approval
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NO. 241

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Banday Elliott			_
Job number: 622800		•	
Part number: DAOG 642 · 541			
Description: 206 skid			
Welding Process: Tig[Mig[]	,	٠.	
Base materiel: Auminia			
Current: AC DC]			

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier De la la la la la la la la la la la la la	Date of Test Coupon 10.09.30 Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.